Work Order ID Tuesday, October 04, 20.						-					Page 1
Item ID: D3405-0 Revision ID: Lug Asset			Accept					Setup	Start Stop		
Start Date: 9/30/201 Required Date: 10/14/20 Reference:				Cust Item I Customer:	D:						1118 181 1181 1 2 81
	s Plan: MC J				ate:]	Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		leject lumber	Insp. Stamp
Draw Nbr	Revision Nbr			s							
Waterjet FLOW CNC Waterjet 354.175	Dwg Rev:_	Dwg D3405 Recessary P (-10-	0.00				BI	<u>(-10</u>	-75		\$.
110 QC Quality Control	QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00				R	- <u>10 -</u>	35	· 	,
120 QC Quality Control	QC8- Inspect parts - seco	and check	0.00 5 //	1,0178	,		(48))			

Dart	Aerospace	Ltd

W/O:			WO	RK ORDER CHANG	=S				-
DATE	STEP	PROC	CEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
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NCR:		· W	ORK ORDE	R NON-CONFORMA	NCE (NCF	?)			
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
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r									

Page 2

Item ID:

D3405-041

Tuesday, October 04, 2011 9:57:33 AM

Accept

Setup Start

Stop



Revision ID:

Item Name:

Lug Assembly

Start Date:

9/30/2011 **Required Date:** 10/14/2011

Start Qty: 6.00

Reg'd Qty: 6.00

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

Date:

Start Run

Reject

Otv



Date:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date:

Tool # Plan

Code

Stop



Insp.

Stamp

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

QC5- Inspect part completeness to step on W/O

Memo

1-Deburr 2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

SB ululos

8

50. 1

Accept

Qty

140

Memo

0.00

0.00

0.00

0.00

Quality Control

150

Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT8484 Identify as D3405-041

M117659

Reject

Number

X7 JBL 11-11-17

Dart Ae	rospace	e Ltd							1
W/O:14	549	B7579	V	WORK ORDER CHANGES					•
DATE	STEP	PROC	EDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No	: <u>D3</u> 0	105~~(PAR #:	_ Fault Ca	ntegory: Lose PAB + Inspection No	CR: Yes	No DQ	4: <u>h</u>	Date: _/	1/11/24
	ı∧(∧R	esolution: 🚙	Disposi	tion: Q	A: N/C C	losed:	4	Date: <u>_</u>	(11/24
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DATE	STEP	Description of NC		Corrective Action Section B		Verific	ation	Approval	Approva
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspecto
	14-	Oty +1 Lost Between welch + instructy. P.C. 100 wer handly Ports.		-7 MARL AS SCROP unalle to PinD	12-11-16			8	
waliz	149	RC 120 120 100	1/2/17	unohuto PinD		Muli	-	057012	Wale 7
,	150	Prosts.	057012		Mh	Mail	7	4/4/17	soluli F

ė										
Work Ord Tuesday, Octob						Pa	ige 3			
Item ID: Revision ID: Item Name:	D3405-041 Lug Assembly			Accept			Setup	Start Stop		
Start Date: Required Date Reference:	9/30/2011	Start Qty: 6.00 Req'd Qty: 6.00	# (0.6%)		Cust Item I Customer:	D:			·	
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	Run	Start Stop		
Sequence ID/ Work Center I 160 	D	Operation Description QC9- Inspect visual per (SI004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Re Qty Qt	-	Reject Insp. Number Stamp	
170 		QC5- Inspect part comple	eteness to step on W/O	0.00	1l	(,	

QC

Quality Control

180

Powdercoat

Powder Coating

W1181351

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

Memo

START TIME: OVEN TEMPERATURE: FINISH TIME:

Dart	Aerospace	Ltd

W/O:				ORK ORDER CHANG	ES				<u>'</u>
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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·						<u> </u>			

Work Order ID 74549



Page 4

Tuesday, October 04, 2011 9:57:33 AM

Item ID:

D3405-041

Accept



Setup Start



Stop

Revision ID:

Item Name:

Lug Assembly

9/30/2011 Req'd Qty: 6.00 Required Date: 10/14/2011

Start Qty: 6.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan: Date:

Tooling:

Date:

Start Run

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

190

OC

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Number Stamp

Insp.

200

Packaging Packaging

Identify as per dwg & Stock Location: 57 478 0.00

0.00

210

OC

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES				•	, ,
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description		ın &	Verific Section		Approval Chief Eng	Approval QC inspector
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Picklist Print

Tuesday, October 04, 2011 9:57:39 AM

Work Order ID: 74549

Parent Item:

D3405-041

Parent Item Name: Lug Assembly



Start Date: 9/30/2011

Required Date: 10/14/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A□05.09.01□New issue□KJ/JLM□

IPP B 09.01.28 rev.B drawing EC verified by:DD

1.	PP B 09.01.28	Tev.b drawing	EC V	erified by.DD									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date g Issued	Status
D3404-1		Manufactured	No	7455	V SX	100	Each	20.0000	1	6	jou ,	11-11-16	
-				Location		Loc	<u>Qty</u>	Loc Code					
				WA			7						
,					70664		7		_				
				WA030			13						
***					72326		13		_				
M304S11GA		Purchased	No	,		150	sf	143.9000	0.154	0.972632	3110-10	- 25	
				Location		Loc C	<u>Oty</u>	Loc Code					
				MAT020		1	43.9					(n	
					117494		15.9		7	17494		(8)	
					119006		64						
					119048		64						

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	SES					, ,
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Part No	·	PAR #:	Fault Cat	egory:	_ NCR: \	es N	o DQ	A:	_ Date: _	· · · · · · · · · · · · · · · · · · ·
	Re	esolution:	Dispositi	on:	QA: N/	C Clos	sed:		Date:	
NCR:		V	VORK ORE	DER NON-CONFORM	ANCE (N	ICR)				
		Description of NC			tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date		on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	74549
Description: GHW Lug	Part Number:	D3405-1 \
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing		Actual	_		Method of			
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments		
Ø0.438	+0.006/-0.001	,439	8		V BOZ			
1.50	+/-0.030	1,505	8		V			
1.750	+/-0.010	1.748	> □		V			
6.751	+/-0.010	6.756	*		V			
8.00	+/-0.030	8.000	→		V			
0.125	+/-0.010	120	2_		V			
	·							

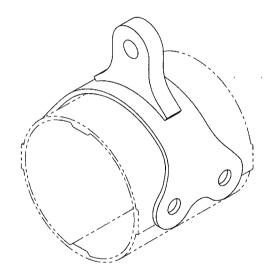
Measured by:	Audited by:	Prototype Approval:	N/A
Date: (1-10 -74	Date: 11/0/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.11.28	New Issue P/O D3405-041	KJ/EC	
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	

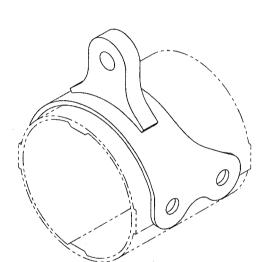
Dart Aerospace Ltd

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DATE	STEP	Description of NC		Corrective Action Se Action Description	Section B Ve			Verification App		Approval			
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ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	
1	Х		D3405-041	LUG ASSEMBLY	
2		х	D3405-043	LUG ASSEMBLY	
11	1	1	D3404-1	GHW LUG	
12	1		D3405-1	GHW BRACKET	
13		1	D3405-3	GHW BRACKET	1



D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)



SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 14549 M.L 11/10/04

D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN FOR REF ONLY)



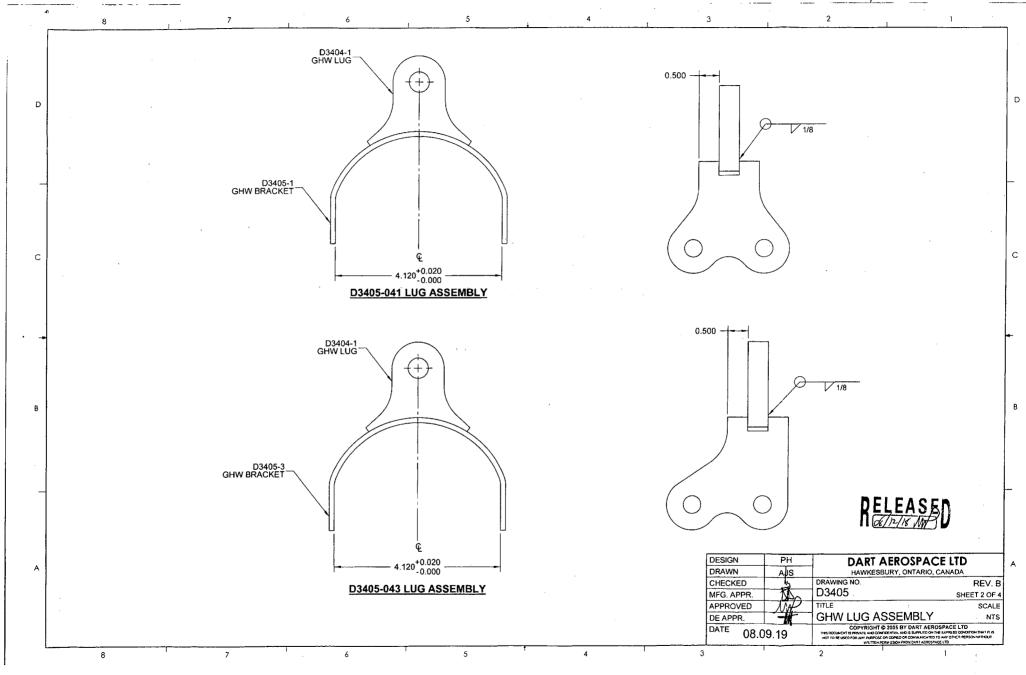
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В	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER FLAT PATTERNS FOR 1 & 3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTI. (SEE PAR198). SHEETS 3 & 4 ZONE 4 6 4.120 DIM WAS 4.100.							
Α	NEW IS	SUE		PH	05.03.08			
REV.			DESCRIPTION	BY	DATE			
DESIG	٧	PH	DART AEROSPA	CEL	TD .			
DRAW	N	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECK	ED		DRAWING NO.		REV. B			
MFG. A	PPR.	Δ	D3405		SHEET 1 OF 4			
APPRO	VED	TW	TITLE		SCALE			
DE APPR.			$\overline{}$ GHW LUG ASSEMBL`	GHW LUG ASSEMBLY				
DATE	08.0	9.19	COPYRIGHT © 2005 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICA MONTHS OF DEPLY STOPPED AND A TEXT OF THE PRIVAL DIES AND MONTHS OF THE PRIVAL DIES AND	ON THE EXPRES	S CONDITION THAT IT IS			

В

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

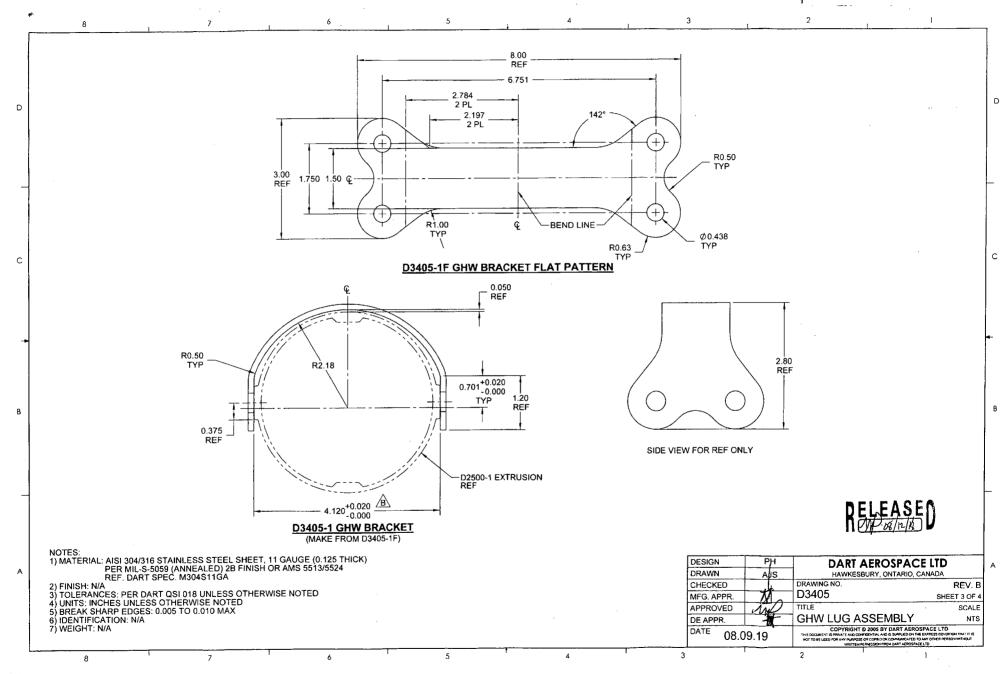
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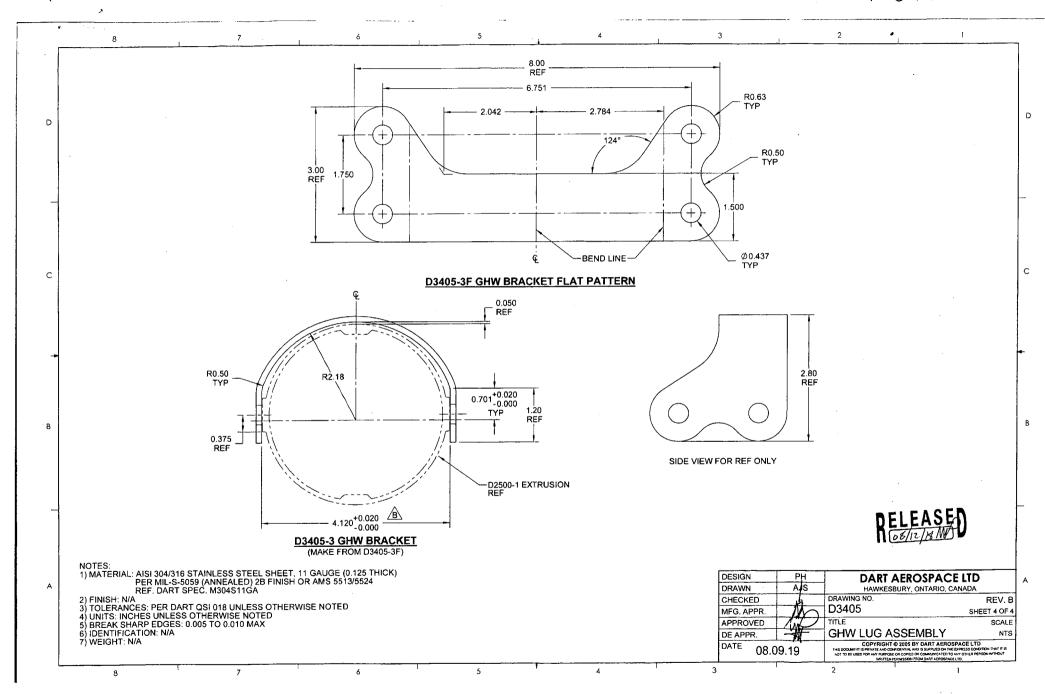


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Dart Ae	rospace	e Ltd										
W/O:			WORK ORDER CHANGES									
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